

Work Order ID 53310

October 29, 2009 3:58:16 PM



Page 1

Item ID: D2829

Accept



Setup Start



Revision ID: B

Stop



Item Name: Threaded Stud

Start Date: 10/29/2009 Start Qty: 16.00



Cust Item ID:

Required Date: 11/3/2009 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 09-10-29

Tooling:

Date:

Run Start



QC: _____ Date: _____

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2829	Rev B								

100



Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

0.00

SA 09/10/30

18



Hardinge CNC Lathe Small

110



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

SA 09/10/30

18



Quality Control

120



QC

QC8- Inspect parts - second check

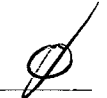
Memo

0.00

0.00

MF 09.11.03

18



Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53310

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Page 2

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Accept



Setup Start



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Item Name: Threaded Stud

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Start Date: 10/29/2009 Start Qty: 16.00



Cust Item ID:

Required Date: 11/3/2009 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PC 9/11/09 (18)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/04

09-11-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 53310



Parent Item: D2829RevB



Parent Item Name: Threaded Stud

Start Date: 10/29/2009

Required Date: 11/3/2009

Comments:

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R0.375 		Purchased	No			110	f	42.2845	1.6842			
304 ROUND BAR 0.375												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

42.28447895

110166

3.32

110472

6.41

112058

0.31317895

- 112473

32.2413

172151 09/10/30

33-

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 53310
Description: Threaded Stud		Part Number: D2829
Inspection Dwg: D2829	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.04	+/-0.030	1.037	/			
0.50	+/-0.030	.50	/			
0.040	+/-0.010	.040	/			
0.50	+/-0.030	.50	/			
1/4-20 UNC-3A	Min: 0.2419 Max: 0.250	.246	/			
5/16-24 UNF-3A	Min: 0.3053 Max: 0.3125	.309	/			
MOW	0.2612-0.2584	.261	/			
MOW	0.3363-0.3336	.334	/			

Measured by: SA	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/10/30	Date: 08.11.03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	[Signature]

276
309

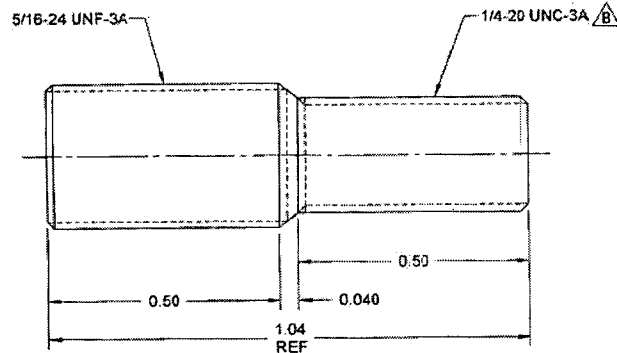
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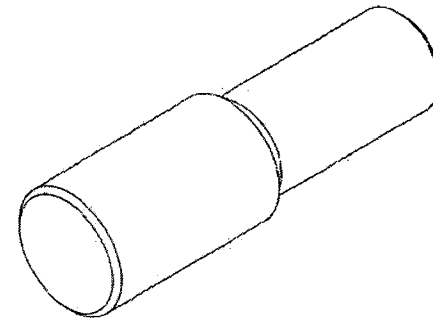
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NOTE: Date & initial all entries



D2829 THREADED STUD



#53310

RELEASED
06/10/29

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. D304RD.DDD
OR
AISI 303 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M303RD.DDD
- 2) FINISH: NONE
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: N/A
- 6) WEIGHT: 0.02 lbs

B	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO 'B' SIZE FORMAT. MATERIAL WAS AISI 4130 (ZIN AG-1); 1/4-20 UNC-3A WAS 1/4-28 UNF-3A (ZIN C2-1). REASON: REVISION OF C2011 FROM REV. F TO REV. G	MB	08.10.03
A	NEW ISSUE	RF	09.05.31
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2829
REV. B
SHEET 1 OF 1

TITLE THREADED STUD
SCALE NTS

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